

# Work Order ID 75005

October-14-11 4:57:21 PM

**\*75005\***

Page 1

Item ID: D2648-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearpad

Start Date: 10/14/11 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 10/20/11 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D2648

Rev D

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2648

\*\*\*\*\*CUT WITH FILE D2648-1\*\*\*\*\*

1010 063

Dwg Rev: B

Prog Rev: D

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

B11-10-17

(2)

B11-10-17

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**\*75005\***

Page 2

Item ID: D2648-3

Revision ID:

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Start Date: 10/14/11 Start Qty: 12.00

Required Date: 10/20/11 Req'd Qty: 12.00

Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Quality Control

Memo

0.00

*Sukdas*

*(420)  
counted*

130

Small Fab

0.00

**\*130\***

Small Fab

Small Fab

Memo

Deburr if necessary

0.00

*N/A*

140

NC BRAKE

0.00

**\*140\***

Brake NC

Brake NC

Memo

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.  
2-Identify as D2648-3

0.00

*SB 11/10/20*

*20*

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**\*75005\***

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**\*N900040100\***

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Revision ID:

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Start Date: 10/14/11 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 10/20/11 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Weld per dwg A/R Hardcoat steel Batch: M11784 0.00

**\*150\***

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

12 11-10-20 RP

160

QC10- Inspect visual per QS1004- ground welds

0.00

**\*160\***

QC

Memo

0.00

Quality Control

Sumo/70

170

QC5- Inspect part completeness to step on W/O

0.00

**\*170\***

QC

Memo

0.00

Quality Control

Sumo/70

Went  
720

# Work Order ID 75005

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**\*75005\***

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Item ID: D2648-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearpad

Start Date: 10/14/11 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 10/20/11 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

**\*180\***

Powdercoat

Powder Coating

Memo

START TIME: 9:00  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 9:30

0.00

190

QC3- Inspect Part Finish

0.00

**\*190\***

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 237 0.00

**\*200\***

Packaging

Memo

0.00

Packaging

20X4 M-11/10/21

20 BR 11-10-21.

11/10/21 SP 20

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**\*75005\***

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**\*N900040100\***Setup Start **\*NS1\***

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

210

QC21- Final Inspection - Work Order Release

0.00

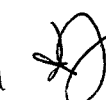
**\*210\***

QC

Memo

0.00

Quality Control

11/10/21 MF  
11-10-21

# Picklist Print

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Page 1

Work Order ID: 75005

Parent Item: D2648-3

Parent Item Name: Wearpad

Start Date: 10/14/11

Required Date: 10/20/11

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: E02.09.18Re-format; Incorporated D2648-1KJ/RF  
IPP Rev:F Now on Waterjet 06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA 1010/1025 sheet 16GA		Purchased	No			100	sf	92.7000	0.075	0.9473684	1.5		

Location

MAT019

116791

117500

118965

Loc Qty

92.7

28.9

31.8

32

Loc Code

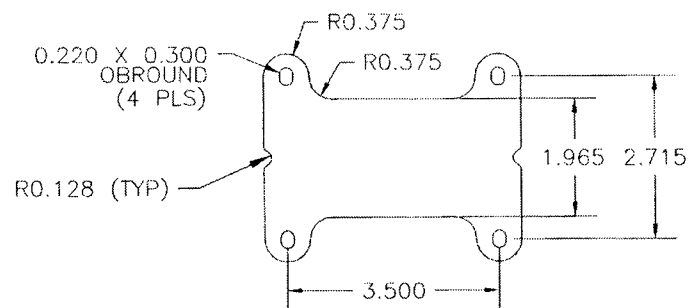
116791

BIT 10 17

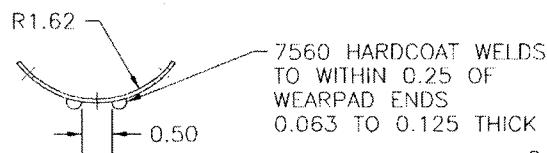
(20)

75005

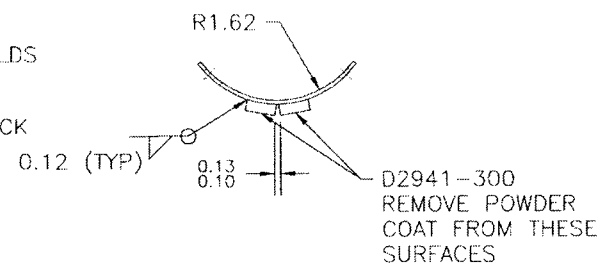
# D2648-1 FLAT PATTERN



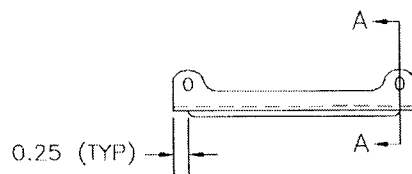
## SECTION A-A



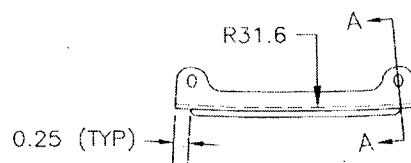
## SECTION B-B



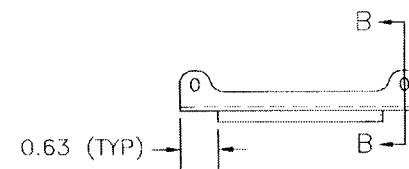
## D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



*WLB 75005*

BREAK ALL SHARP CORNERS 0.063 MAX  
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

RELEASED



D	99.11.17	ADDED D2648-7	
C	97.06.26	R31.6 WAS R19.6	
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250	
A	97.03.25	NEW ISSUE	
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. RELEVANT, WA	
CHECKED	APPROVED	DRAWING NO. D2648	REV. D SHEET 1 OF 1
DATE		TITLE WEARPAD	SCALE 1:2
99.11.17			